

FIG. 1 PRIOR ART

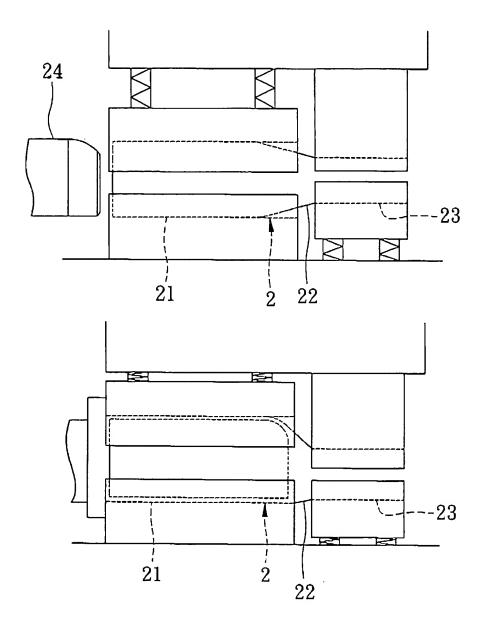


FIG. 2 PRIOR ART

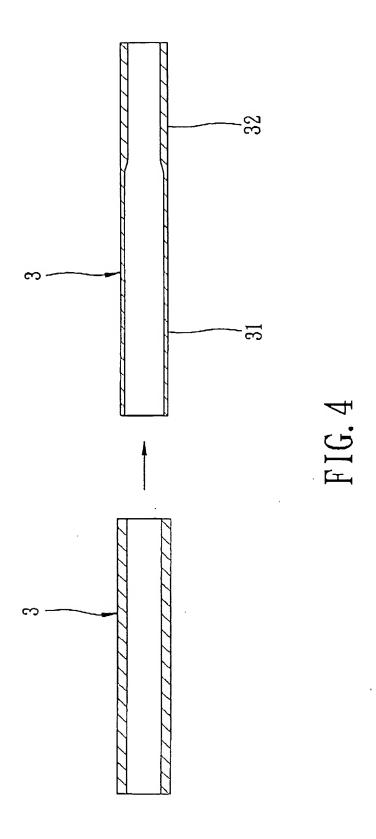
Preparing an aluminum alloy tube having a predetermined length

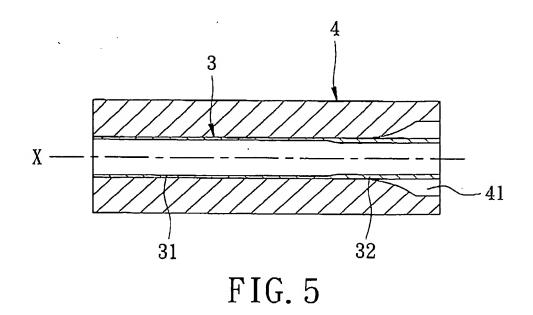
Drawing the aluminum alloy tube to form a thin section and a thick end section

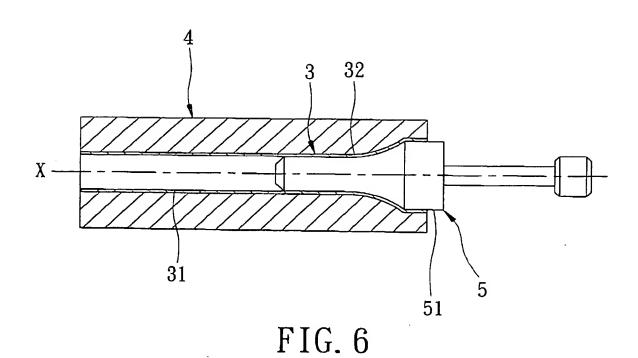
Radially and proportionally enlarging the cross-section of the thick end section of the aluminum alloy tube in a first die using a first mandrel

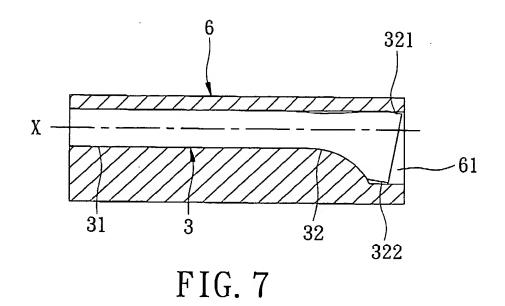
Disproportionally varying the cross-section of the thick end section of the aluminum alloy tube in a second die using a second mandrel

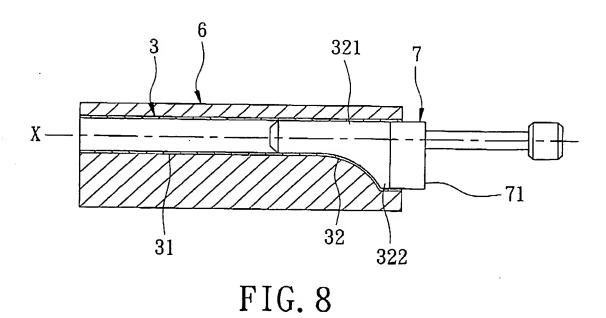
FIG. 3











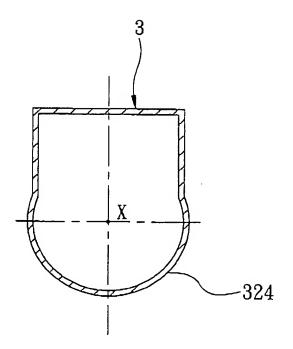


FIG. 9

